

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016974**Date Inspected:** 23-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Yu Dong Ping/ Mr. Qiu Wen			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Tower	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 10

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040302 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A5-025-134. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 057258 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A5-027-135. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

Bay no. 11

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040736 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A7-020-145. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

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4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040667 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A5-020-058/059. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 054460/044541 perform SMAW welding on; Tower Lift 5 Brackets and the weld joint is identified as ND1-BRSA5-2-12B, 8B. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U4B. (Photo attached)

6. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 041271 / 046769 perform FCAW welding on; Tower Lift 5 Brackets and the weld joint is identified as SD1-BRSA5-1-9A, 13A. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U4B.

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as OBG Bottom panel, Lift 14 at Bay no. 10 (Notification no. 06746) and Cross Bracing Gusset at Tower trial assembly, Heavy Dock (Notification no. 06740). The weld designation reviewed is as follows:

NSD1-FASA3-1 C/E –Jt. no. 12 –Heavy Dock

BP 3094-001 – Jt. nos -12,18,19,39,41,54,58,65,71,72,105,106,107 –Bottom panel, Lift 14

BP 3094-001 – Jt. nos -204,205,206,216,217,237,238,247,248,290,291 –Bottom panel, Lift 14

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Tower, Lift 5 -Bracket welding at Bay no. 11



ORG -Bike path corner plate welding at Bay no. 10 -FCAW



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar,Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer